

Work Order ID 96745

February-01-13 8:30:34 AM

96745

Page 1

Item ID: D3265-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Rib

Stop

NS2

Start Date: 2/01/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/15/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: *MLJ*

Date: *13-02-01*

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3265	E								
100		0.00							
100	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- cut D3265-1 rib as per dwg 2- remove identification markings 3- deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <i>WA005</i>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

Pl 13.2.1

10

(15) 13-02-01

DAS

Pl 13.2.1

10

Work Order ID 96745

February-01-13 8:30:34 AM

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Page 2

Item ID: D3265-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib

Start Date: 2/01/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/15/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ 13-02-04

pl 13-02-1

Picklist Print

February-01-13 8:30:38 AM

Page 1

Work Order ID: 96745

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Parent Item: D3265-1

D3265-1

Parent Item Name: Rib

Start Date: 2/01/13

Required Date: 2/15/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 12.07.26 AS PER DWG REV.D DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.750W.065

Purchased

No

100

f

2,299.153

4.729

49.77895

M304TS0 750W 065

**

CPC13.2.1

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT017

1448.153597

122468

448.153597

124069

1000

WA006

851

122051

41

123303

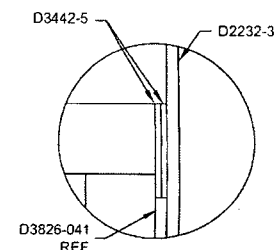
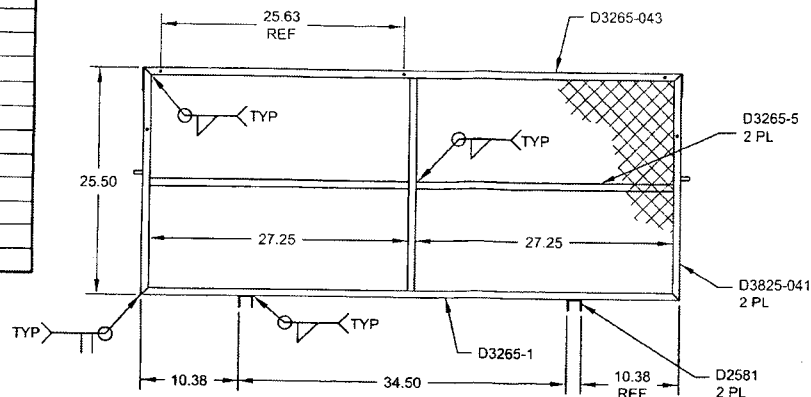
769

7636

41

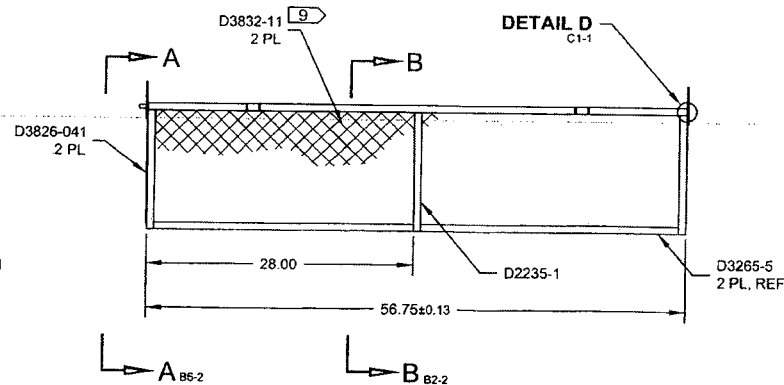
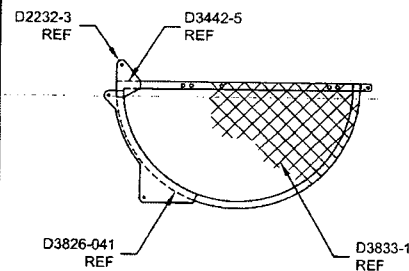
~~49.78~~ 49.78

QTY -041	PART NUMBER	DESCRIPTION
X	D3265-041	BASKET BASE ASSY
2	D2232-3	HINGE PLATE
1	D2235-1	RIB
2	D2581	MOUNTING BRACKET
1	D3265-1	RIB
1	D3265-043	RIB ASSY
2	D3265-5	RIB
4	D3442-5	SHIM
2	D3825-041	RIB ASSY
2	D3826-041	RIB/GUSSET ASSY
1	D3832-11	MESH (BASE, SM)
2	D3833-1	MESH, BASE END FACE



DETAIL D C4-1
(BOTH ENDS)
SCALE 10X



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2012-08-03



D3265-041 BASKET BASE ASSEMBLY

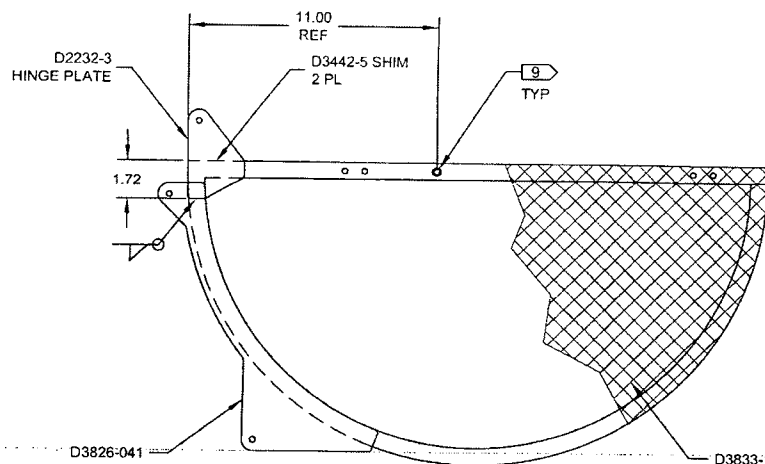
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) SKIN INSIDE SURFACE OF BASKET WITH D3832-11, TACK WELD EACH END OF STRAND TO FRAME

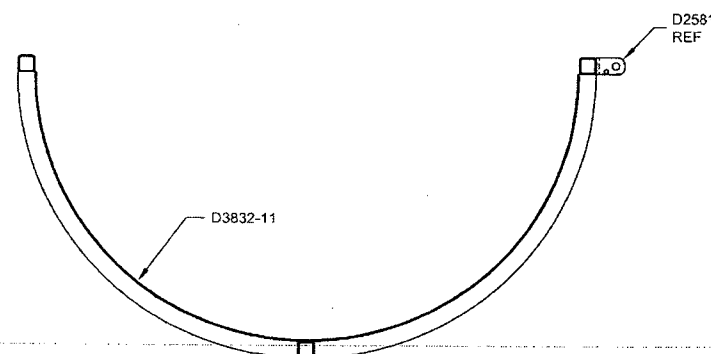
E	CORRECTED 53.25 DIM SHIFED AT LAST REV (ZNC3-3).	MB	12.07.26
D	REVISED PARTS LIST: QTY(2) D3826-041 REPLACE QTY(4) D2325 & QTY(2) D2235-1; QTY(1) D3265-043 REPLACES QTY(1) D3265-1; QTY(4) D3442-5 WAS QTY(2); REMOVE D3265-3 ADD D3265-7; D3825-041 WAS D3265-3; CREATED D3265-043; ADDED D3832-11 AND D3833-1. REASON: PAR10-50.	MB	12.05.14
C	DRAWING UPDATED TO CURRENT STANDARDS. SHT 4 ADDED. RIB MATERIAL WAS 0.060 THICK. SHT 2 ZONE D5 25.63 DIMENSION WAS 27.63.	AJS	08.08.14
B	INCORPORATED A1. ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS.	PH	05.06.08
A	NEW ISSUE	CP	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3265	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	12.07.26	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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WORK ORDER
96745 MJS
13-02-a

96745



SECTION A-A B6-1
2 PL
(BOTH END RIBS)



SECTION B-B B5-1
2 PL
(BOTH CENTER RIBS)

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2012-08-03
JMP

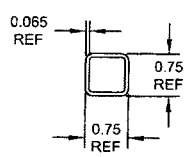
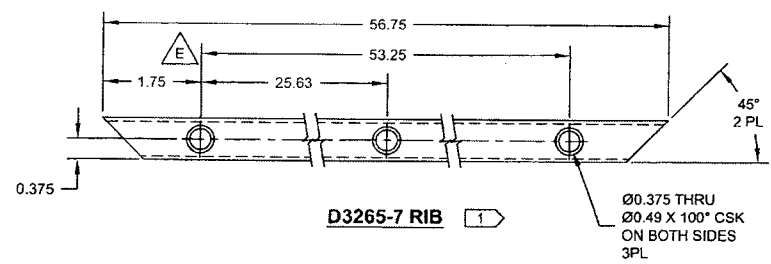
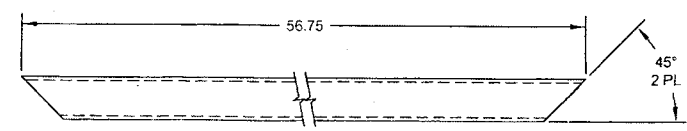
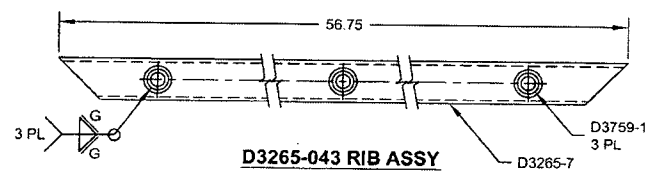
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) TRIM EXPANDED METAL LOCALLY AS REQUIRED, TYP BOTH ENDS

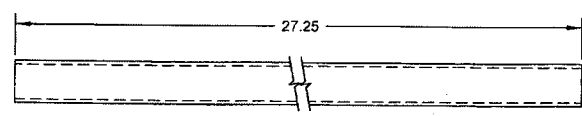
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CHECKED		DRAWING NO. D3265	REV. E
MFG. APPR.		TITLE	SHEET 2 OF 3
APPROVED		BASKET BASE ASSEMBLY (350)	SCALE
DE APPR.			NTS
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96745

QTY	PART NUMBER	DESCRIPTION
-043		
X	D3265-043	RIB ASSY
1	D3265-7	RIB
3	D3759-1	BUSHING



TYP SECTION



RELEASED
2012-08-03
WA

- NOTES:
- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING
PER ASTM A554/A269 MILL FINISH, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC M304TS0.750W.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) WELDING: PER DART QSI 004

DESIGN	DS	DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3265	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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